Work Order I June-12-13 9:13:45			*102	770*						Page 1	: ! :
Revision ID:	213-3 or Panel		Accept	*N900	<b>040</b>	100	)* s	Setup St	1	NS1* NS2*	; ;
Start Date: 6/1 Required Date: 6/1 Reference:	1/13 Start Qty: 8.00 1/13 Req'd Qty: 8.00	*8* *8*		Cust Item   Customer:	D:						
	rocess Plan:M_JC:	Date: 13 -06- L			ate:		R		art *	NR1* NR2*	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Rejec Num		· :
Draw Nbr	Revision Nbr										
D3213	В										
*100 *100* Waterjet	FLOW WATER JET  Memo		0.00					O		JM 13-0	7-21
PLOW CNC Waterjet	DWG: Rau B Prog: Rev B										
*110 *110*	QC2- Inspect parts off m	achine FAI/FAIB	0.00				18	٥			57-21
QC Quality Control	Мето		0.00								
*120 *120*	QC8- Inspect parts - sec	ond check	0.00	S 2\s			10				!
· QC	Memo		0.00	7 m							- q

DQA:			Date:						•				
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		Vork Order u	ndate only	AEROSPACE
QA Closed.			Date.							· · · · · ·		<u> </u>	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
	_					Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	io.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	_					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	۰. No	······································				Suspected Unapproved			Large Fab	Composite		Supplier	
Root					Docc	ription of work order update		nitial	Act	ion	Sign &		T
Cause		Date	Step	Qty	Desci	or non-conformance	1	iief Eng	1	ription	Date	Verification	QC Inspector
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	<del></del>	Bending			<u> </u>	Bend		1	Program	-	Outside Dim	<del> </del>	Pressure/Forced
	$\vdash$		ot Concer	ntric	<u> </u>	BOM/Route	$\perp$	Grain		<u> </u>	Over/Under	<del>-</del>	Set-up
:	-	Cracks			$\vdash$	Broken/Damage/Defect	$\vdash$	Hardwa		_	Part Incorre	<b>}</b>	Temperature/Cure
	$\vdash$	•	nk/Ripple	/Wave	ļ	Burrs	<u> </u>	1 `	ion Incomplete/Ur	· –	Part Lost/M	-	Weld
	$\overline{}$	Cuffs			<u> </u>	Contamination	<u> </u>	1.	tions Incomplete/U	Jnclear	Part Moved		Wrong Stock Pulled
	—-	Crushing				Countersink	_	• •	gned/off center	<u> </u>	Positioned \		
	$\vdash$	Heat Trea			<u> </u>	Cut Too Short	34	Mislab		L	Power Loss/	Surge	Other
	⊢	•	n Strip in	Tube	<u> </u>	Drawing	_	Misrea					
	-	Marks/Ch				Drill Holes	$\vdash$	Off-set					
	_	_	equence		<u> </u>	Finish		-1	Calibration		<u> </u>		
	IΙ	Nave/Tw	ist in Tuk	ne .		Fit/Function	1	I Out of	Seguence				

H:/FORMS/Quality Assurance\approved QA/NCRWO RevH

Work Ord June-12-13 9:1		2770		*102	Page 2								
Item ID: Revision ID: Item Name: Start Date: Required Date: Reference:	D3213-3  Door Panel 6/11/13 6/11/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*	Accept	*N900040100  Cust Item ID: Customer:				etup Sta	I VI	INIT		
approvals:	Process Pla	an:	Date:			ate:		R	tun Sta	I/I	R1* R2*		
Sequence ID/ Work Center I 30 *120* Småll Fab Småll Fab	D	Operation Description Small Fab Memo Deburr		Set Up/ Run Hours 0.00	Tool ID		Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp		
40 *140* HandFinish land Finishing		Chemical Conversion Co	oat per QS1005 4.1	0.00				jO	H	9713.4	7-23		
50, \$150*		QC3- Inspect Part Finish	ı	0.00				10					
QC Quality Control		Memo		0.00 13 7	. 24			<u>, )                                   </u>					

WORK ORDER NON-CONFORMANCE / UPDATE  OA Closed: Date: Work Order update only  Work Order:  Part No. Scrap Use-as-is NCR No. Suspected Unapproved Use-as-is Suspected Unapproved Description of work order update Initial Action Sign &  Work Order update only  AGAINST DEPARTMENT/PROCESS  Water Skid-tube Crosstube Prod. Eng. Co  Machining Small Fab Prod. Eng. Co  Thermoforming Finishing Rec/Store/Package  Large Fab Composite Supp	S  Jet Engineering  oor. Quality  ging Other
Work Order:    Rework	F Jet Engineering Outher
Part No.  Scrap Use-as-is NCR No.  Suspected Unapproved  Rework Skid-tube Crosstube Small Fab Prod. Eng. Co Thermoforming Large Fab Composite Supp	oor. Quality Ging Other
Part No. Scrap Machining Small Fab Prod. Eng. Composite Suspected Unapproved Large Fab Composite Supp	oor. Quality Ging Other
NCR No.  Use-as-is  Use-as-is  Thermoforming  Finishing  Rec/Store/Package  Suspected Unapproved  Large Fab  Composite  Supp	ging Other
	olier
Root Description of work order update Initial Action Sign &	
Cause         Date         Step         Qty         or non-conformance         Chief Eng         Description         Date         Verification	ation QC Inspector
Design	
Doc/Data Doc/Data	
Equip/Tooling	
Handling/Pre	
Material	
Operator	
Offset/Setup	
Process	
Supplier	
Training	
Transport	·
Unapproved	
FAULT CATEGORY	
Landing Gear General General	
Bending Bend Folio/Program Outside Dimensions	Pressure/Forced
Centre Not Concentric BOM/Route Grain Over/Under tolerance	Set-up
Cracks Broken/Damage/Defect Hardware Part Incorrect	Temperature/Cure
Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing	Weld
Cuffs Contamination Instructions Incomplete/Unclear Part Moved	Wrong Stock Pulled
Crushing Countersink Misaligned/off center Positioned Wrong	
Heat Treat Cut Too Short Mislabeled Power Loss/Surge	Other
Inspection Strip in Tube Drawing Misread	
Marks/Chatter Drill Holes Off-set	
Turning Sequence Finish Out of Calibration	
Wave/Twist in Tube Fit/Function Out of Sequence	

0.00

Memo

Quality Control

MLS 13-09-76 CMF 13-7-24

DQA:			Date:			WORK ORDER NON-	cc	NEO	DNANICE / III	DDATE				TOART
QA Closed:			Date:			WORK ORDER NON-		JINFOI	RIVIAINCE / O		Wo	ork Order up	date only	AEROSPACE
Work Orde	٠.٠					DISPOSITION			<u> </u>	AGAINST	DEI	PARTMENT	PROCESS	
	-					Rework		Skid-tube Crosstube				_	Water Jet	Engineering
Part N	lo					Scrap			Machining	Small Fab			d. Eng. Coor.	Quality
NCR N	10	· · · · · · · · · · · · · · · · · · ·				Use-as-is Suspected Unapproved	<b>-                                    </b>			Finishing Composite				
Root					Desci	ription of work order update		nitial	Act	tion		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription		Date	Verification	QC Inspector
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Landii						General		]		!		ام بدنید منس		Pressure/Forced
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	$\vdash$	Cracks	or concer	ILTIC	$\vdash$	Broken/Damage/Defect	-	1			-	Over/Under Part Incorred	<del></del>	Temperature/Cure
	-	Crimp/Kir	d /Dinnla	Maria	-			Hardwa		ngualified	├	t	<del>}</del>	Weld
		Cuffs	ik) kibbie	y wave	-	Burrs Contamination		1	ion Incomplete/Ui ions Incomplete/U	-	-	Part Lost/Mi Part Moved	221118	Wrong Stock Pulled
	$\vdash$	Crushing			-	Countersink	-	4	ned/off center	Unclear	_	Positioned V	Vrong.	
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	-	Inspection		Tube	-	Drawing	$\vdash$	Misrea			L	Ji Owei 1035/	Juige	Totalei
	$\vdash$	Marks/Ch		TUDE	<del> </del>	Drill Holes	$\vdash$	Off-set				<del></del>		
	${f H}$				<del> </del>	Finish	$\vdash$	1						
	Turning Sequence  Wave/Twist in Tube				Fit/Function	Out of Calibration Out of Sequence								

Required Date: 6/11/13

Required Qty: 8.00

**Start Date:** 6/11/13

Start Qty: 8.00

## Picklist Print

June-12-13 9:13:45 AM

Work Order ID:

102770

Parent Item:

. Comments:

D3213-3

Parent Item Name:

Door Panel

IPP Rev:A

05-11-17 JLM

New Issue

	IPP Rev:B	Now on Waterjet	07-02-13	JLM			,						
Component Item ID/	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seg ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>M2024T3S.063</b> 2024-T3 .063 sheet		Purchased	No			100	sf	575.3089	0.4714	3.969684	D0: 146 1		Jm13-07-2
				Location		Loc Qty	Lo	c Code					
				MAT022		575.3089							
				119	916	0.2							
				121	197	21.34							
				123	8096	11.4							
=				123	3654	11.64							
4				123	3701	51.7289				<u>.</u>			
	İ			125	341	95							
* :				125	6636	384			135	<u>636</u>			

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QA Closed:			Date:			WORK ORDER NON-	-00	JINFOI	NIVIAIVCE / UI		ork Order up	odate only	AEROSPACE	
Work Orde						DISPOSITION			,	AGAINST D	EPARTMENT/PROCESS			
WORK OTGE					_	Rework			Skid-tube	Crosstube	7	Water Jet	Engineering	
Part N	10					Scrap		1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality	
						Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other	
NCR N	VO. —					Suspected Unapproved	roved Large Fab Composite			Supplier				
Root					Desci	ription of work order update	1	nitial	Act	tion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector	
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	В	ending				Bend	L	Folio/F	rogram		Outside Dim	ensions	Pressure/Forced	
		entre No	ot Concer	ntric		BOM/Route	L	Grain			Over/Under	tolerance	Set-up	
		racks				Broken/Damage/Defect		Hardwa	ire	L	Part Incorre	ct	Temperature/Cure	
		rimp/Kir	nk/Ripple	/Wave		Burrs	<u> </u>	Inspect	ion Incomplete/U	nqualified	Part Lost/Mi	ssing	Weld	
	<del></del>	uffs			<u> </u>	Contamination	<u></u>	4	tions Incomplete/	Unclear	Part Moved		Wrong Stock Pulled	
	${f H}$	crushing				Countersink	$ldsymbol{ld}}}}}}}}$	1	ned/off center		Positioned V		_	
	-	leat Trea				Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other	
	$\vdash$	•	n Strip in	Tube		Drawing	L	Misrea						
	-	/larks/Ch				Drill Holes		Off-set						
		_	equence			Finish	<u>_</u>	4	Calibration					
	Wave/Twist in Tube				Fit/Function	1	Out of	Sequence						

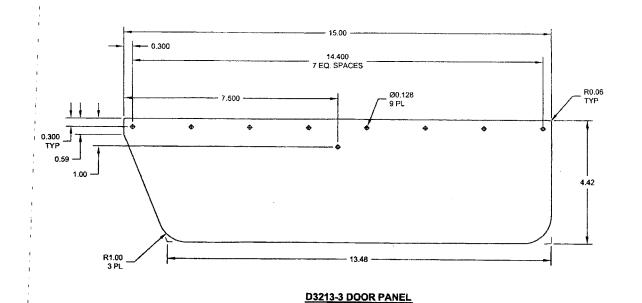
DART AEROSPACE LTD	Work Order:	0FF501
Description: Door Panel	Part Number:	D3213-3
Inspection Dwg: D3213 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

+/-0.030 +/-0.010 +/-0.010	Dimension 15.00° 0.306°	Accept	Reject	Method of Inspection	- Comments
+/-0.010		-			
			1	T	Jamo6
+/-0.010	0.200	-		V	Jamob Jamos
17-0.010	14.400			7	,
+0.005/-0.001		_		V	
+/-0.030				V	
+/-0.030		_		V	
+/-0.010	0.304"			ν	
+/-0.005	2.058"	_		V	
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	7/1				
		<del>-</del>			
		W			
	+0.005/-0.001 +/-0.030 +/-0.030 +/-0.010	+0.005/-0.001 O. 125" +/-0.030	+0.005/-0.001 O, 135" - +/-0.030	+0.005/-0.001 O, 125" - +/-0.030	+0.005/-0.001 O, 125" - V +/-0.030

Measured by:	Jm	Audited by:	\$ > to	Preliminary Approval:	
Date:	13-57-21	Date:	13 ? 20	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
В	04.06.15	Tolerance changed for 14.400 dimension	KJ/JLM	
С	08.11.27	Diameter symbol added to dimension 0.128	KJ/EC , A	
D	12.05.14	Dwg Rev updated	KJ OU	1.11



D

D3213-3 NOTES:

1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4
OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF. DART SPEC M2024T3S.063
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHAPP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.39 lbs

DESIGN	90	DART AEROSI	PACE LTD		
DRAWN	12	HAWKESBURY, ONTA			
CHECKED	a	DRAWING NO.	REV. B		
MFG. APPR.	B	D3213	SHEET 4 OF 4		
APPROVED	JUNO	TITLE	SCALE		
DE APPR.	#	DOOR ASSEMBLY	NTS		
DATE 11.0	06.06	COPYRIGHT 6 2003 BY DARY AEROSPACE LYD THIS DOCUMENT IS PRIVATE AND CONFEDERING, AND IS SUFFICIOUS THE COMESS CONDITION THAT IT IS HOT TO BE USED FOR ANY PARPOSE OR COMED ON COMMENSIONED. O ANY OTHER PERSONNETHED AND ANY PARPOSE LYD. WHITTHE PERSONNETHED AND ANY FREEDOM SET THE			